

Work Order ID 82558

82558

Page 1

April-03-12 8:33:23 AM

Item ID: D4148-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4148

D

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

5X Ø 12/04/17

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

8/26/17

(X)

120

Identify as per dwg & Stock Location: 468

0.00

120

Packaging

Memo

0.00

Packaging

(S) 12/4/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82558***82558***

Page 2

April-03-12 8:33:23 AM

Item ID: D4148-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Lug Assembly, Fwd

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/4/12
MF
12-04-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April-03-12 8:33:28 AM

Page 1

Work Order ID: 82558

82558

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	583.0000	4	10			
MS21043-3									**				
Nut													
				<u>Location</u>				<u>Loc Qty</u>					
				FG				72					
					103691			72					
				GA				252					
					120693			252					
				ST301				259					
					118077			2					
					118614			207					
					118686			30					
					119758			20					
MS21043-4		Purchased	No			100	Each	1,930.000	1	15			
MS21043-4									**				
Nut													
				<u>Location</u>				<u>Loc Qty</u>					
				FG				40					
					104603			40					
				ST301				1890					
					119546			370					
					120308			520					
					121162			1000					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April-03-12 8:33:28 AM

Page 2

Work Order ID: 82558

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

82558

D4148-041

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 5.00

Required Qty: 5.00

D2690-6 Manufactured No

100 Each 15.0000 1 5

D2690-6

Lanyard Assembly

**

EP 12/04/17

B82061 (5x)

Location

Loc Qty

Loc Code

ST016

15

79515

15

D3910-1 Manufactured No

100 Each 0.0000 1 5

D3910-1

Crosstube Lug

**

EP 12/04/17

D4091-1 Manufactured No

100 Each 9.0000 1 5

D4091-1

Mounting Lug

**

EP 12/04/17

8146 (5x)

Location

Loc Qty

Loc Code

ST458

9

81005

9

D4148-1 Manufactured No

100 Each 25.0000 2 10

D4148-1

Crosstube Lug Plate, Fwd

**

EP 12/04/17

B82046 (9x)

Location

Loc Qty

Loc Code

ST132

25

78331

13

81477

12

D4148-3 Manufactured No

100 Each 3.0000 1 5

D4148-3

Stud Receiver, Lower

**

EP 12/04/17

Location

Loc Qty

Loc Code

ST133

3

79055

3

B82311 (3x)
B 79055 3x
79055

April-03-12 8:33:28 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

Work Order ID: 82558

82558

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 5.00

Required Qty: 5.00

D4148-5 Manufactured No

100 Each 20.0000 1

D4148-5

Eyebolt Stud

**

5
EP 12/04/17

Location

Loc Qty

Loc Code

ST133

20

81405

20

AN3C12A Purchased No

100 Each 344.0000 2

AN3C12A

Bolts

**

5
10
EP 12/04/17

Location

Loc Qty

Loc Code

GA

50

120449

50

ST351

294

117514

4

118112

5

118451

22

119510

1

120423

212

121259

50

AN4C13A Purchased No

100 Each 189.0000 3

AN4C13A

BOLT

**

15
EP 12/04/17

Location

Loc Qty

Loc Code

ST307

100

121166

100

ST357

89

120187

1

120423

88

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82558

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

82558

D4148-041

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 5.00

Required Qty: 5.00

MS17984-C413

Purchased

No

100

Each

46.0000

1

5

MS17984-C413

PIN, QUICK RELEASE

**

GP 12/04/17

Location

Loc Qty

Loc Code

ST315

3

114340

1

118612

2

ST333

3

121011

3

ST335

40

121091

40

5

MS20615-4M18

Purchased

No

100

Each

244.0000

8

40

MS20615-4M18

Rivet

**

GP 12/04/17

Location

Loc Qty

Loc Code

ST323

244

118077

80

118543

164

28
12

NAS1149C0332R

Purchased

No

100

Each

1,182.000

4

20

NAS1149C0332R

Washer

**

GP 12/04/17

Location

Loc Qty

Loc Code

ST297

1182

118354

355

119736

196

120648

631

M12/255
(200)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

Work Order ID: 82558

82558

Parent Item: D4148-041

D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149C0432R

Purchased

No

100

Each

2,278.000

6

30

NAS1149C0432R

**

Washer

EP 12/04/17
30

Location

Loc Qty

Loc Code

ST297

2278

117291

1278

119124

1000

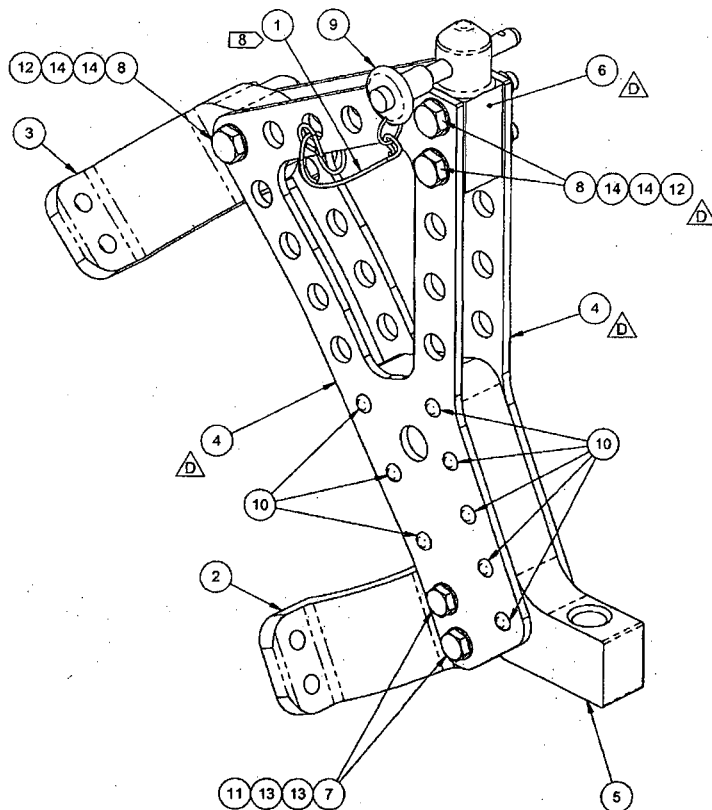
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82558 *MLJ*
12/04/03

RELEASED
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.260" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.129 7 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4148** REV. D
SHEET 1 OF 5
TITLE **FWD X-TUBE LUG ASSY** SCALE NTS

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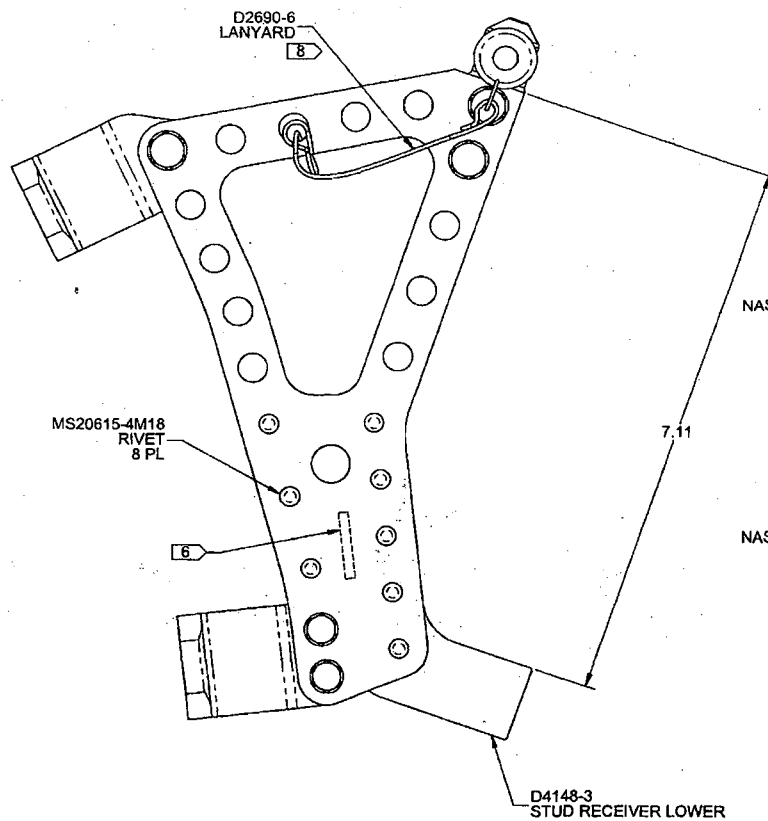
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

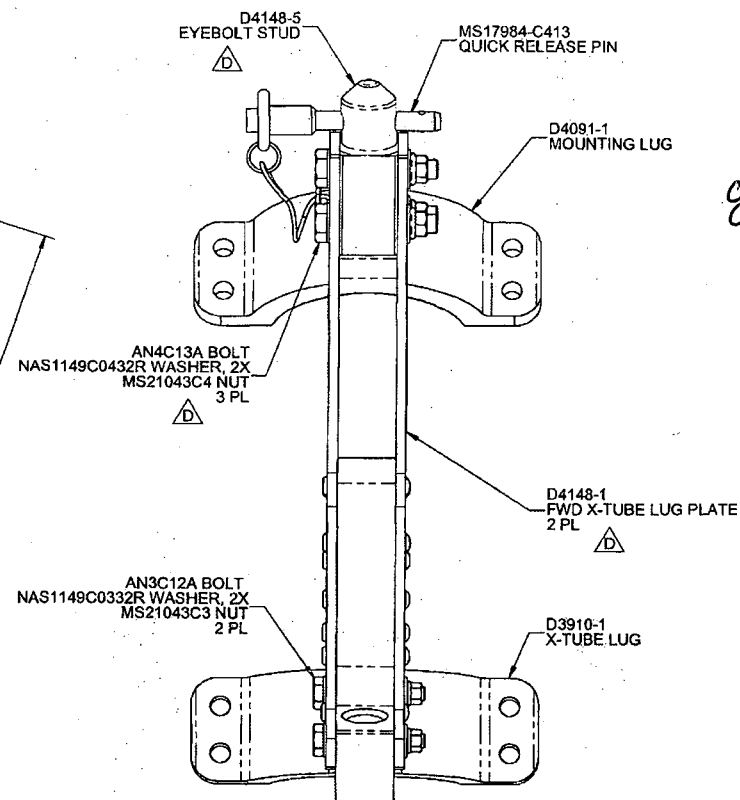
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY



RELEASED
2011-02-20
JP

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS TO BE USED ONLY FOR THE PURPOSES AND CONDITIONS SPECIFIED IN THE AGREEMENT. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

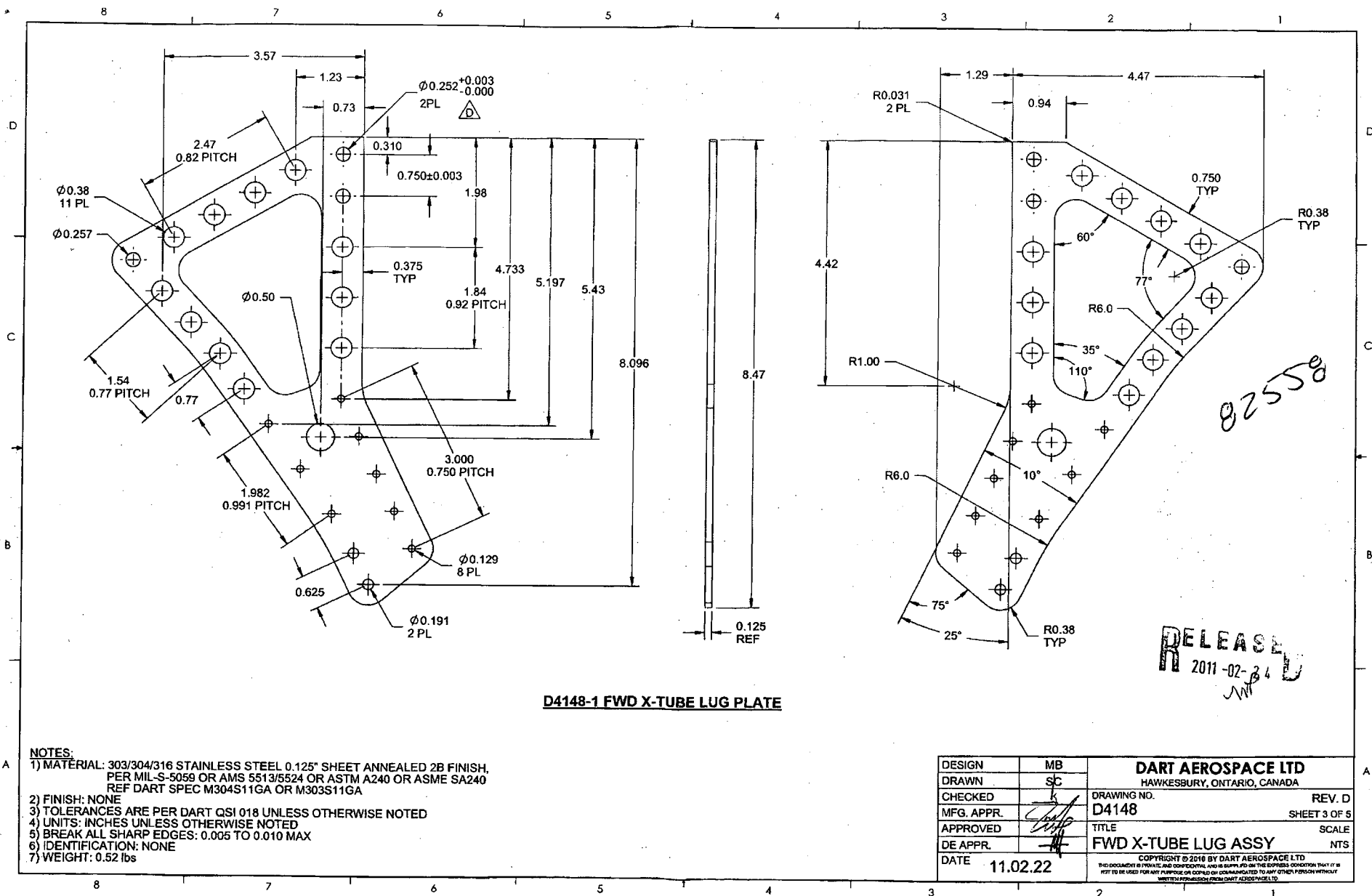
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. D4148	REV. D
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		FWD X-TUBE LUG ASSY	SCALE
DE APPR.			NTS
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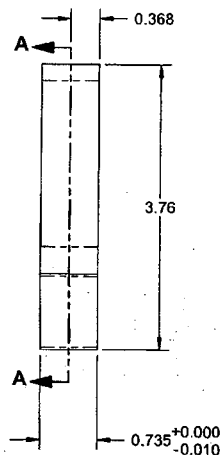
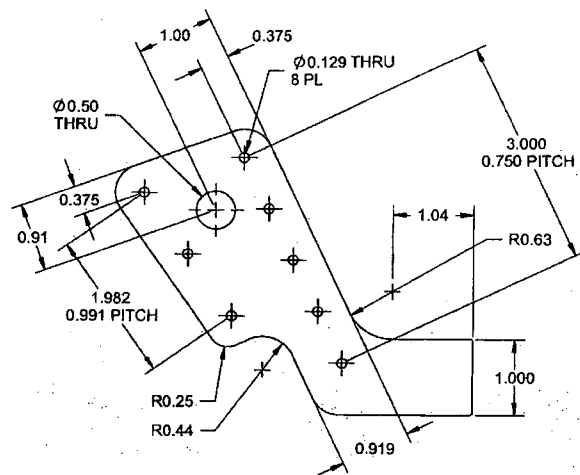
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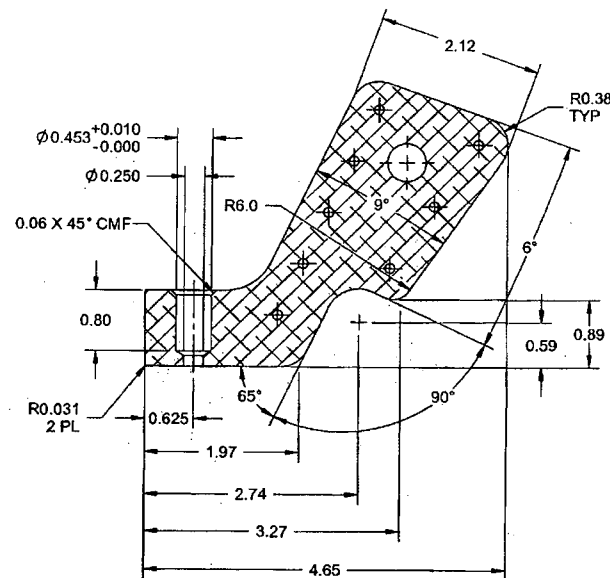
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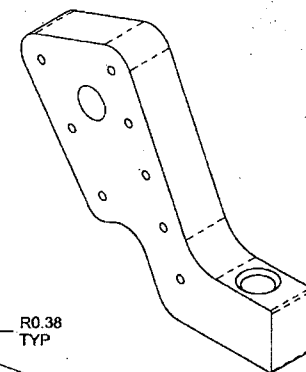
NOTE: Date & initial all entries



D4148-3 STUD RECEIVER LOWER



SECTION A-A



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 4 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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2011-02-31

W/O:		WORK ORDER CHANGES					
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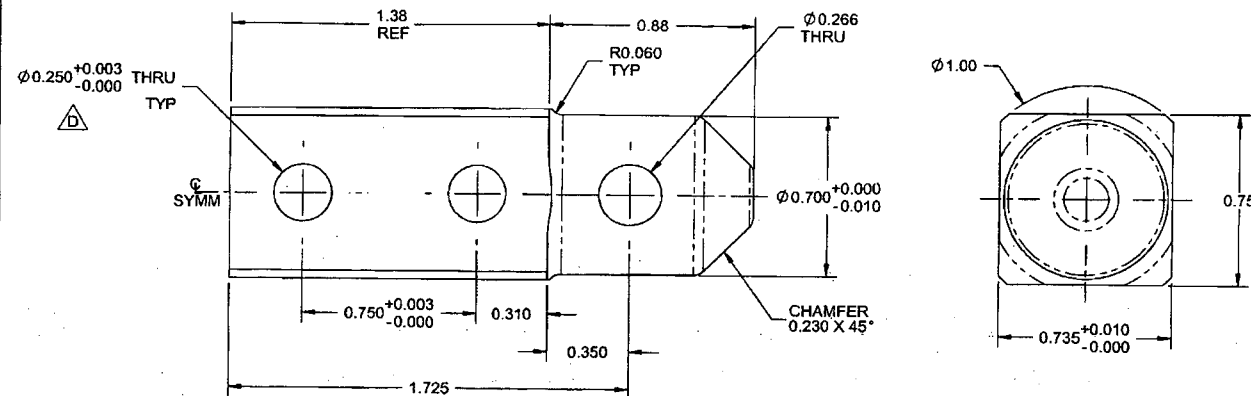
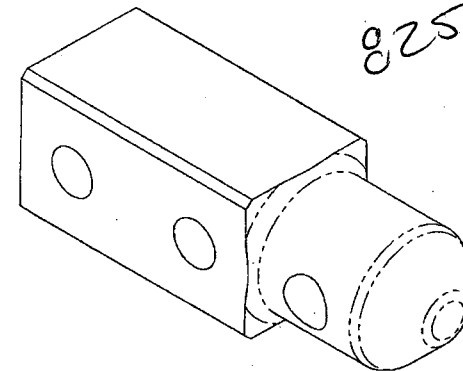
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NOTE: Date & initial all entries

82558



D4148-5 EYEBOLT STUD

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 5 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries